

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021498**Date Inspected:** 06-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 12AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated SEG3001Y-020, 021, Deck Plate I-rib hold back weld. The welder is identified as #200113 and was observed welding in the 4F(overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated SEG3001Y-027, 028, Deck Plate I-rib hold back weld. The welder is identified as #067656 and was observed welding in the 4F(overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as LI Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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Segment 12BE/12CE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Side Plate transverse splice, cross beam and bike path side.

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Side Plate transverse splice, cross beam side.

Segment 12BW/12CW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Bottom Plate transverse splice.

Segment 12BW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Bottom Plate to Side Plate hold back weld, cross beam side at the east end of the segment.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Due to inclement Weather work in the OBG Trial Assembly was limited.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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Inspected By: Hernandez,Dan

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer